

Date: Thursday, 3/8/2007 12:32:40 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEB
Job Number : 31114	
Estimate Number : 10482	
P.O. Number : N/A	Part Number : D2923
This Issue : 3/8/2007 S.O. No. : N/A	Drawing Number : D2923 REV.A
Prsht Rev : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : A
Previous Run : 29229	Material : N/A
	Due Date : 4/3/2007
Written By : _____	Qty: 3/ Um: Each
Checked & Approved By : <u>07.03.08</u>	
Comment : Est. B 02.07.26 Updated Location RF	

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
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1.0000	D26005108	Extrusion 'I Beam' thin
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P.O. Number



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

D2600-5-108 Extrusion 'I Beam' thin

Previous Run

Batch: B 24410

JD 7-3-12

Um: Each

Written By

2.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1

Checked & Approved By



Comment: LANDING GEAR RESOURCE 1

Cut D2600-5 Extrusion to length as per Dwg D2923.

Deburr ends

JD 7-3-12

3.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Drill pilot holes in web as per Dwg D2923 using drill jig DT8481

2- Open holes to finish size as per Dwg D2923.

3- Deburr

JD 7-3-12

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 07-03-21(5)

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-3-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 12:32:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 31114

Part Number: D2923

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 07-01-21 (5)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LC

BE 07-01-21 (5)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

BE 07-03-01

Job Completion



LC 07-03-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

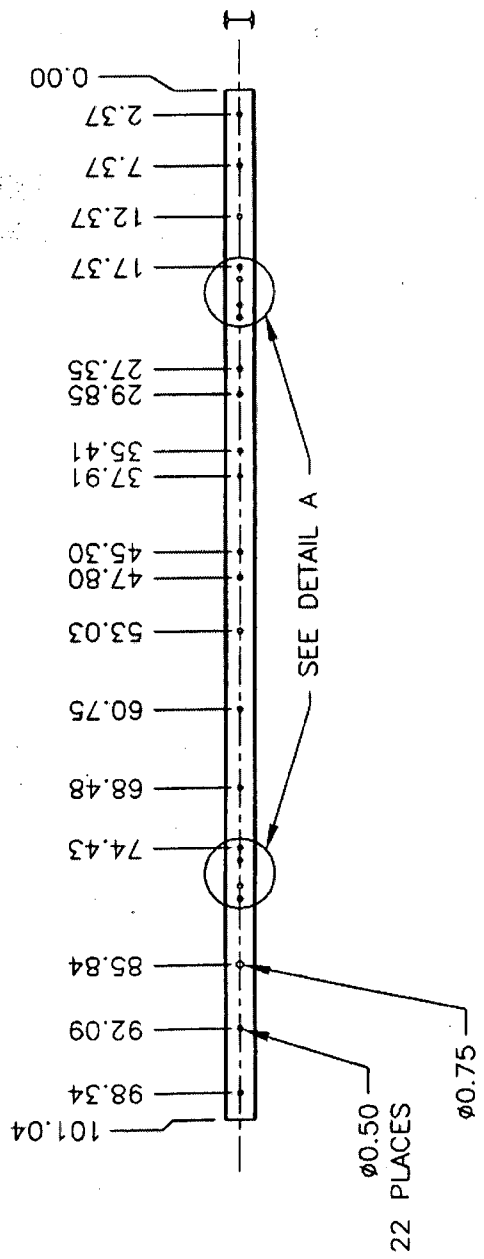
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

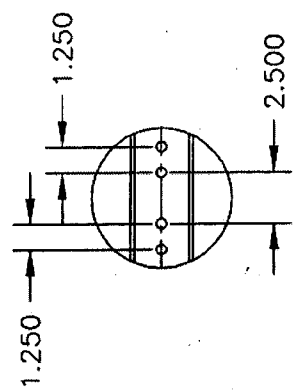


DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2923	REV. A SHEET 1 OF 1
DATE 99.10.14		TITLE WEB	SCALE 1:18
A	99.10.14	NEW ISSUE	

RELEASED
00.05.11



DETAIL A
SCALE 1:9



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31114

MAKE FROM D2600-5 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED